

# Work Order ID 51637

August 27, 2009 8:28:21 AM



Page 1

Item ID: D3536-39

Accept



Setup Start



Revision ID: A

Stop



Item Name: Gasket

Start Date: 8/27/09

Start Qty: 5.00



Cust Item ID:

Required Date: 9/11/09

Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date:

*08-28-09*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3536

Rev A

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3536 | Dwg Rev: A | Prog Rev: A | 12-  
Deburr if necessary

*B 9-9-9*

*(12)*

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

*B 9-9-9*

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

*2) 802/01/10*

*(12) /*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 51637**

August 27, 2009 8:28:21 AM

Page 2

Item ID: D3536-39

Revision ID: A

Item Name: Gasket

Start Date: 8/27/09 Start Qty: 5.00

Required Date: 9/11/09 Req'd Qty: 5.00

Reference:

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Identify as per dwg & Stock Location: FP 11

0.00



Packaging

Memo

0.00

Packaging

9/9/10 (12x) SJ

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/09/11 HJ

w Bl. 09.11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

August 27, 2009 8:28:21 AM

Page 1

Work Order ID: 51637

Parent Item: D3536-39RevA

Parent Item Name: Gasket

Comments:

Start Date: 8/27/09

Required Date: 9/11/09

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	638.9541	3.9653	9.5167		



NEOPRENE SHEET 0.063



B 999

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	638.9540585	
111469	71.1	
111853	167.854059	
112508	400	

NONE  
NONE  
112508

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 51637
<b>Description:</b> Gasket		<b>Part Number:</b> D3536-39
<b>Inspection Dwg:</b> D3536	<b>Rev:</b> A	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
35.71	+/-0.030	35.71	*			
32.78	+/-0.030	32.78	*			
29.28	+/-0.030	29.28	*			
25.78	+/-0.030	25.78	*			
23.25	+/-0.030	23.25	*			
19.75	+/-0.030	19.75	*			
17.75	+/-0.030	17.25	*			
14.25	+/-0.030	14.25	*			
9.50	+/-0.030	9.50	*			
4.75	+/-0.030	4.75	*			
5.00	+/-0.030	5.00	*			
9.00	+/-0.030	9.00	*			
0.30	+/-0.030	.301	*			
0.30	+/-0.030	.301	*			
1.88	+/-0.030	1.900	*			
Ø0.19	+0.005/-0.001	.190	*			
0.063	+/-0.010	.064	*			

<b>Measured by:</b> B	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 9-9-9	<b>Date:</b> 09/05/10	<b>Date:</b>	N/A

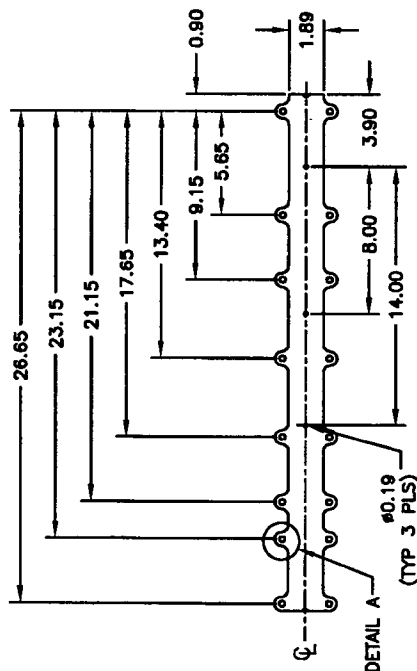
<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A	07.03.14	New Issue	KJ/JLM	[Signature]



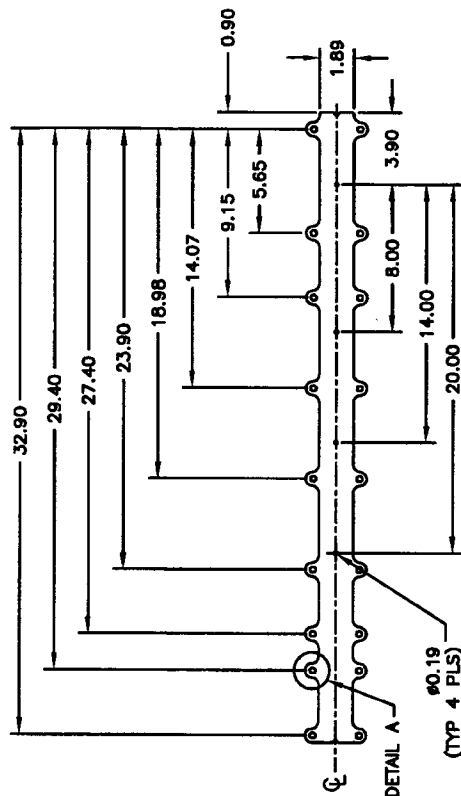
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CHECKED <b>PH</b>	APPROVED <b>[Signature]</b>	DRAWING NO. D3536	REV. A SHEET 1 OF 6
DATE 06.10.25		TITLE GASKET	SCALE 1:10
A	06.10.25	NEW ISSUE	

RELEASED

07.02.12



**D3536-11 GASKET**



**D3536-13 GASKET**

- NOTES**
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
  - 2) FINISH: NONE
  - 3) PART IS SYMMETRICAL ABOUT  $\phi$
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 5) ALL DIMENSIONS ARE IN INCHES
  - 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
  - 7) SEE PAGE 6 FOR DETAILS AND SECTION

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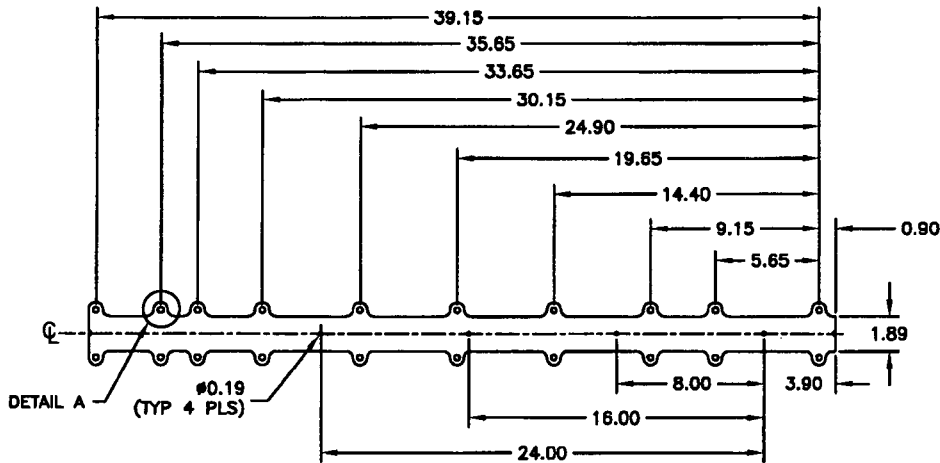
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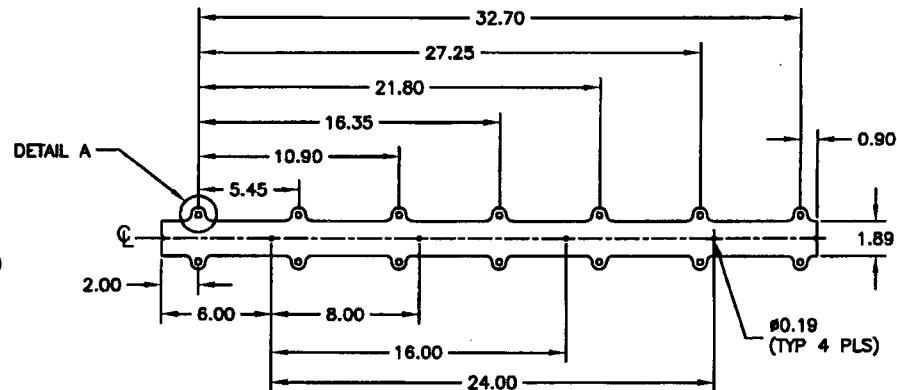
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CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	D3536	REV. A
			GASKET	SHEET 2 OF 6
				SCALE 1:10

RELEASED  
07.02.12



**D3536-15 GASKET**



**D3536-21 GASKET**

51637

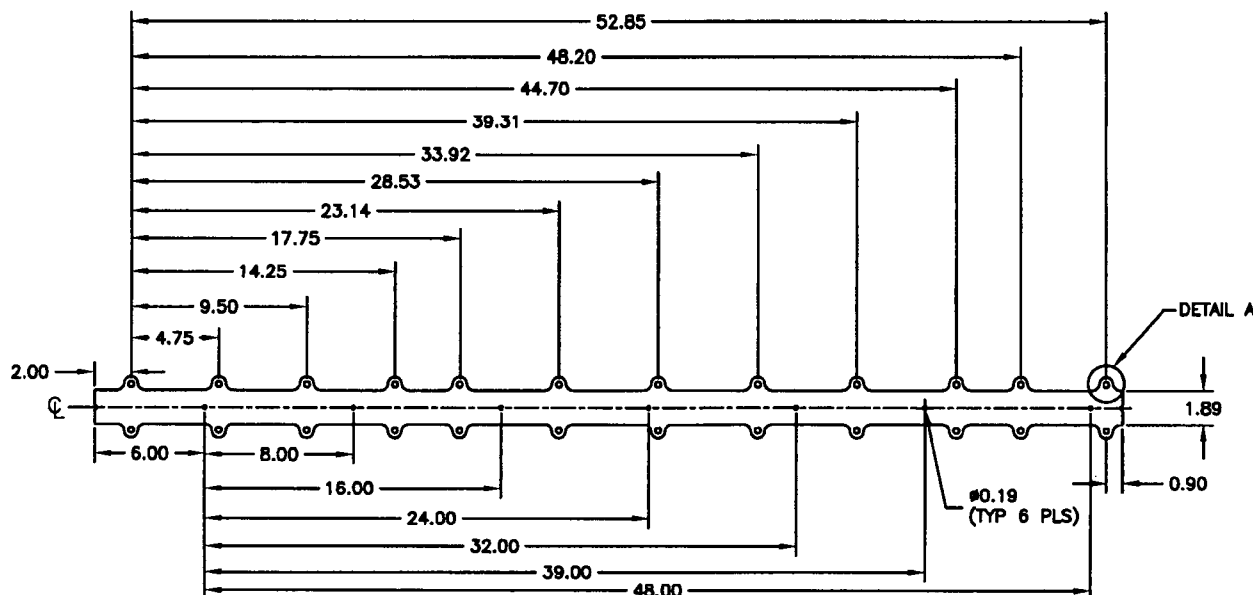
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- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
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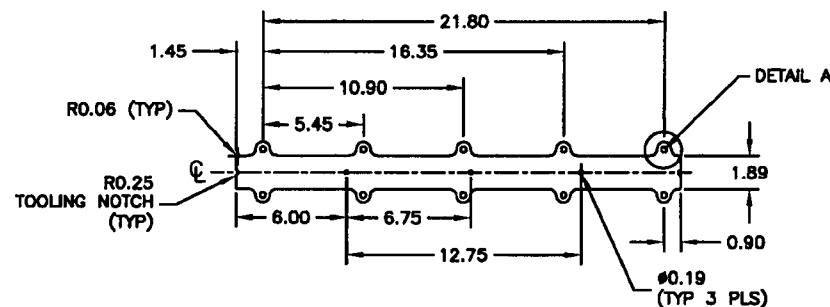
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CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	GASKET	REV. A
		DRAWING NO.	D3536	SHEET 3 OF 6
		SCALE	1:10	

RELEASED  
070212



**D3536-23 GASKET**



**D3536-25 GASKET**

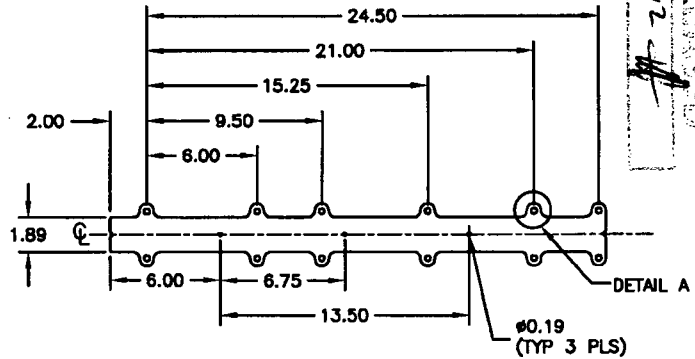
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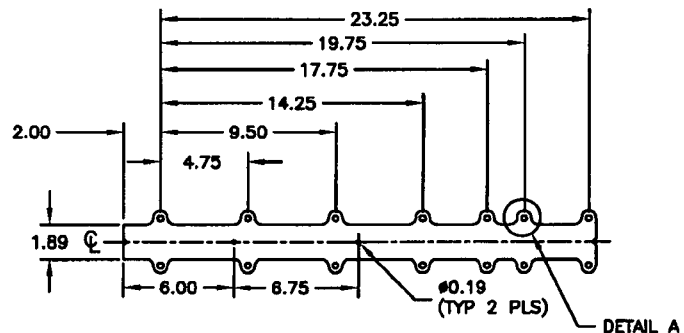
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DATE	06.10.25	TITLE	D3536	REV. A
			GASKET	SHEET 4 OF 6
				SCALE 1:10

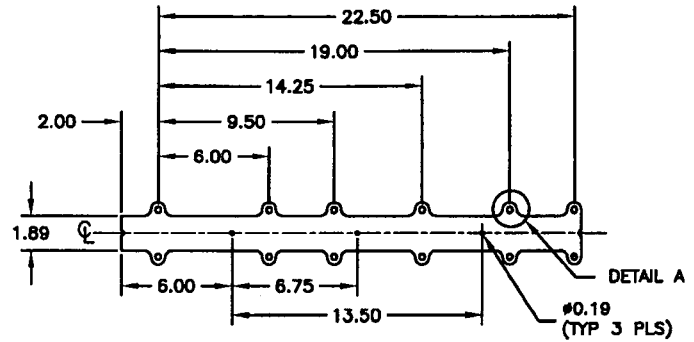
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**D3536-33 GASKET**



**D3536-35 GASKET**



**D3536-31 GASKET**

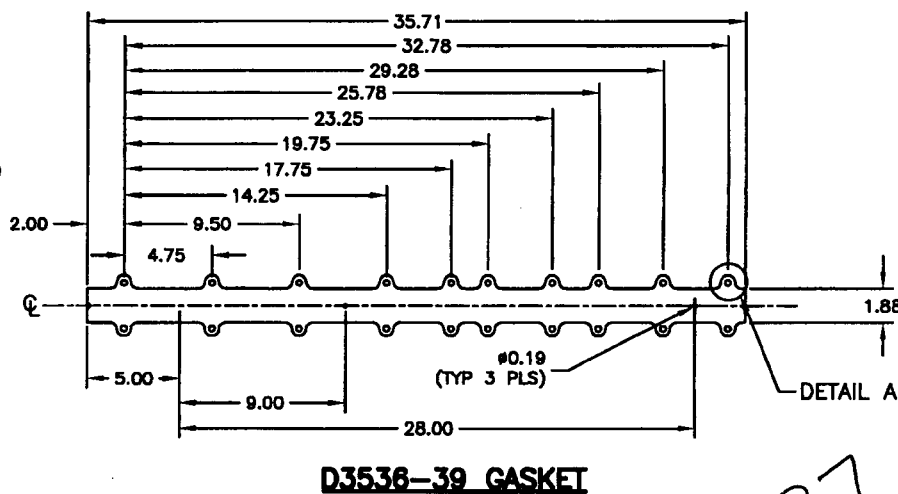
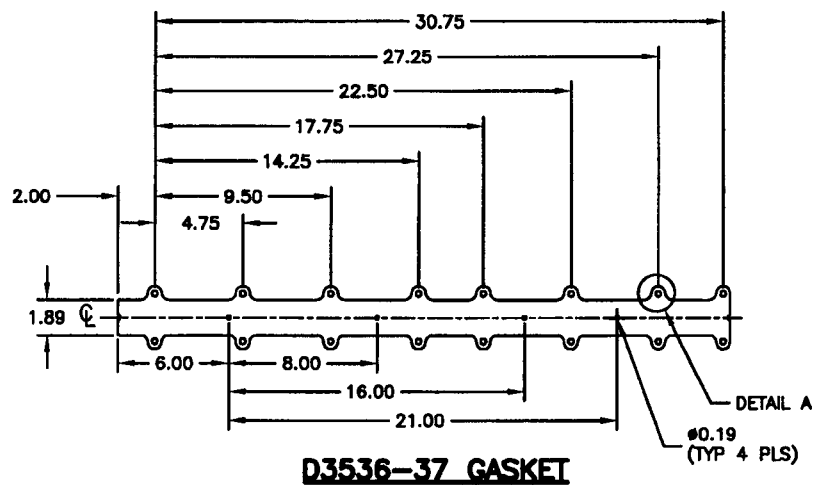
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CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 5 OF 6
				SCALE 1:10

07.02.12  
07.02.12  
07.02.12



**NOTES**

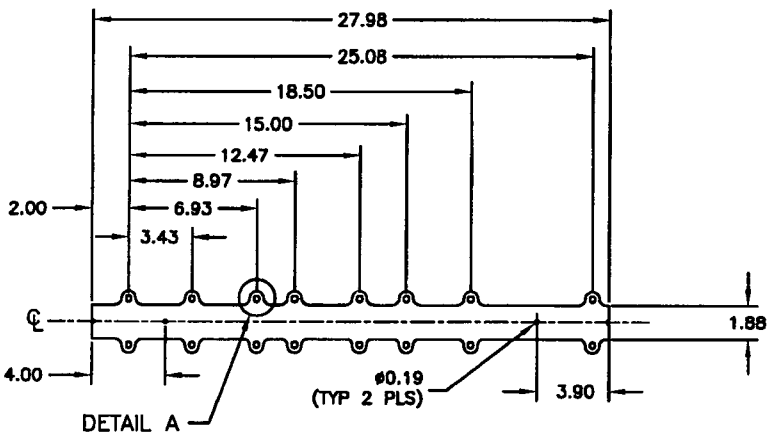
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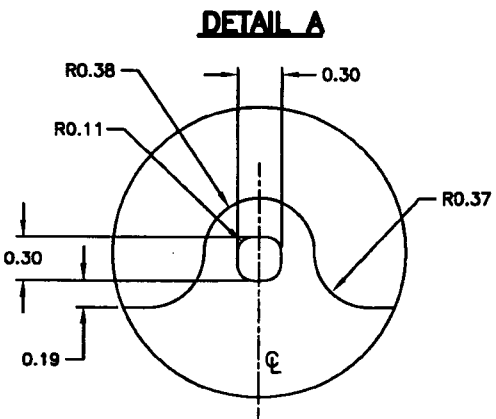
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DATE	06.10.25			TITLE	GASKET
				SCALE	1:10

07-22-12-4



**D3536-41 GASKET**



51637

## NOTES

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